

Work Order ID 76971

76971

Page 1

Thursday, November 24, 2011 1:32:52 PM

Item ID: D206-559-021

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 11/24/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-559

rev L

100

DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-021 CHG007

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

MCJ 12/02/2011

95, 12/02/27

(2x) SP12-02-27

8 12/02/27

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-021 Location: U

Rev A

21228 sf 120

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 12/02/28mf
12-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 76971

76971

Parent Item: D206-559-021

D206-559-021

Parent Item Name: Bearpaw

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.17Blank size changedKJ/JLM
IPP Rev:D 07-01-02 Was K10005 JLM
IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:F 08-05-05 up a chg DD verified by:EC
IPP Rev:G New Manufacturing Method 08-10-29 JLM Verified By:EC
IPP RevH 10.10.04 per DS19527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A		Purchased	No			160	Each	604.0000	8	16			

AN4-17A

Bolt

**

M/20187 SP L

Location	Loc Qty	Loc Code
ST358	4	
116419	0	
116704	0	
117619	4	
ST359	600	
118628	300	
118983	300	

AN4-20A

Purchased

No

160

Each

572.0000

8

16

AN4-20A

Bolt

**

SP L

Location	Loc Qty	Loc Code
ST359	572	
117514	272	
118983	100	
119127	200	

AN960JD416

NAS1149D0463J Purchased

No

160

Each

0.0000

16

32

AN960JD416

Washer

**

M/119075
SP 12-02-27 L

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Thursday, November 24, 2011 1:32:58 PM

Work Order ID: 76971

76971

Parent Item: D206-559-021

D206-559-021

Parent Item Name: Bearpaw

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

D2182B Manufactured No

160 f

725.2542 1.67 3.34

D2182B

Rubber Cushion

**

3.34

Location

Loc Qty

Loc Code

ST410

725.25417

66063

59.94817

73932

665.306

3.34x

(D2182B050) cut qty (4) at 5.00" as per dwg ***per kit***

D2274 Manufactured No

160 Each

463.0000 8

D2274

Radius Block

**

16

B78589 16 SP.

Location

Loc Qty

Loc Code

ST010

250

72121

16

73389

234

ST139

213

74435

213

D2438 Manufactured No

160 Each

229.0000 4 8

D2438

Clamp

**

B77038 8x

8P 12-02-27

Location

Loc Qty

Loc Code

ST456

229

69737

84

73400

145

Thursday, November 24, 2011 1:32:58 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Parent Item: D206-559-021

D206-559-021

Parent Item Name: Bearpaw

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

D2529 Manufactured No

160 Each

792.0000

8

16

D2529

Washer

**

B79221/16x SP

Location

Loc Qty

Loc Code

ST016

792

71161

250

73486

42

76086

500

D2671 Manufactured No

160 Each

0.0000

2

4

D2671

Bearpaw, 206 Narrow

MS21042L4

**

B76969 SP

Purchased No

160 Each

10,757.00

8

16

MS21042L4

Nut

**

SP 12-02-27

Location

Loc Qty

Loc Code

ST300

546

117441

51

117601

362

118451

133

ST516

5211

119017

5211

ST518

5000

119075

5000

16x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D206-559-021

D206-559-021

Parent Item Name: Bearpaw

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 2.00

Required Qty: 2.00

QS200-M44S

Purchased

No

160

Each

46.0000


2

4

QS200-M44S

Clamp

**

1119436
~~1116727~~ 4X
 SP 12-02-27


Location

Loc Qty

Loc Code

ST449

16

115589

3

117460

13

ST455

30

119436

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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2

Customer:

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Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-559

rev L

100

DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-021 CHG007

M.C.J 12/02/24

(2)

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

REFERENCE ONLY

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP